Work Order ID 99285 Page 1 April-05-13 1:12:58 PM Item ID: D3255-3 Accept *N900040100* Setup Start Revision ID: Stop Item Name: Cap Start Otv: \$\\00 Start Date: 4/04/13 **Cust Item ID:** Reg'd Oty: Required Date: 4/12/13 **Customer:** Reference: Run Approvals: Process Plan: MCJ Date: 13-04-08 Tooling: Date: Stop OC: Date: SPC(Y/N): Date: Sequence ID/ Operation Set Up/ **Tool ID** Tool # Plan Reject Reject Accept Insp. Work Center ID Description **Run Hours** Code Oty Otv Number Stamp Draw Nbr **Revision Nbr** D3255 Rev B 100 0.00 FLOW WATER JET *100* 20 0 JM13-07-30 Waterjet 0.00 Memo B Prog Rev: B 2-FLOW CNC Waterjet 1-Cut as per Dwg D3255 Dwg Rev: Deburr if necessary 304 .032 110 QC2- Inspect parts off machine FAI/FAIB 0.00 *110* 200 0.00 Memo Quality Control

120

QC8- Inspect parts - second check

0.00

(2) 13-07-30

120

Memo

0.00

Quality Control

	1								·	DQA:	Date:		
NCR: Yes	/ No			wo	RK ORDER NON-C	OI	NFORN	/ANCE / UP		QA Closed:	Date:		
Work Order:	1				DISPOSITION				AGAINST DEI	PARTMENT	/PROCESS		
work Order.			···		Rework	1		Skid-tube	Crosstube		Water Jet	Engineering	1
Part No.					Scrap	1	I .	Machining	Small Fab	Pro	d. Eng. Coor.	Quality	1
					Use-as-is	1	Therm	noforming	Finishing	Rec/Stor	re/Packaging	Other	
NCR No.	:			\	Work Order Update]		Large Fab	Composite		Supplier		
	·						<u> </u>						_
Root				Description o	f work order update		Initial	Ac	ction	Sign &			
Cause	Date	Step	Qty	or Non-	conformance	Cr	nief Eng	Desc	ription	Date	Verification	QC Inspector	
Doc/Data													
Equip/Tooling													
Operator													
Material			ļ										
Setup													
Other]										

			FAU	LI CATEGORY		
Landing	Gear	General			 _	
	Bending	Bend		Grain	Ovalized	Pressure/Forced
	Centre Not Concentric to O/S	BOM/Route		Hardware	Over/Under tolerance	Temperature/Cure
	Cracks	Broken/Damaged		Inspection Incomplete	Part Incorrect	Weld
	Crushed/Crimped	Burrs		Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled
	Cuffs	Contamination		Maintenance	Part Moved	
	Heat Treat	Countersink		Mislabeled	Positioned Wrong	 _
	Inspection Strip in Tube	Cut Too Short		Misread	Power Loss/Surge	Other
	Ripples in Bend	Drill Holes		Offset		
	Torque Waves in Extrusion	Drawing		Out of Calibration		
	Turning Sequence	Finish		Out of Sequence		
	Wave/Twist in Tube	Folio		Outside Dimensions		

Process
Supplier
Training
Unapproved

Work Orde		285		*992	285*							Page 2	2
Revision ID:	D3255-3			Accept	*N900	040	100)*	Setup	Start Stop	1 71	S1* S2*	
	4/04/13	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item I Customer:	D:					IV.	. 7/	
Approvals:		n:	Date:	Tooling: SPC (Y/N):		ate:			Run	Start Stop	*N *N	R1* R2*	
Sequence ID/ Work Center II)	Operation Description Identify as per dwg & Sto	ock Location: WA	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept	t Re Qt	-	Reject Number	Insp. Stamp	
120 Packaging Packaging		Memo ****STOC	'K IN LARGE FAB****	0.00				20					JBC
140		QC21- Final Inspection -	· Work Order Release	0.00							- 0		
140 QC Quality Control		Memo		0.00					1 <u>C</u> 3	— ` м V	5 17	3-07-3	3)

	NCR: Yes /		WORK ORDER NON-C	ONFO	RMANCE / UPI	DATE	QA Closed:	Date:	
	Vork Order:		DISPOSITION			AGAINST DE	PARTMENT/		,
	Part No NCR No		Rework Scrap Use-as-is Work Order Update	Th	Skid-tube Machining ermoforming Large Fab	Crosstube Small Fab Finishing Composite	1	Water Jet d. Eng. Coor. ee/Packaging Supplier	Engineering Quality Other
	Poot	Descri	ntion of work order undate	Initia	Ι Δα	tion	Sign &		
Step Ot			•		I		Date	Verification	QC Inspector
	poc/Data uip/Tooling perator aterial tup ther ocess applier aining napproved								
i	<u>, , , , , , , , , , , , , , , , , , , </u>			AULT CA	TEGORY				···
Crimped it n Strip in Tub n Bend Vaves in Extru	Bridge Br	Tube	Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing	Hard Insp Inst Ma Mis Mis Offs	dware ection Incomplete ructions Incomplete/ intenance abeled read et of Calibration	'Unclear	Part Incorre Part Lost/M Part Moved Positioned V	ct issing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
()	uip/Tooling perator aterial tup ther ocess applier aining mapproved Branch Ge Co	crimped ; ; t' n'Strip in ' Bend	Step Qty Ot Concentric to O/S Crimped t	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Bend Drill Holes Caves in Extrusion Tour Tous Tous Tous Tous Tous Tous Tous Tous	Step Qty or Non-conformance Chief E FAULT CA General Bend BOM/Route Hard Broken/Damaged Insp Crimped Burrs Instruction Mai Contamination Mai Countersink Mish Strip in Tube Cut Too Short Mish Bend Drill Holes Offs Vaves in Extrusion Drawing Out	Step Qty or Non-conformance Chief Eng Description FAULT CATEGORY General Bend Grain Hardware Hardware Inspection Incomplete Crimped Burrs Instructions Incomplete Crimped Countersink Maintenance t Countersink Mislabeled n Strip in Tube Cut Too Short Misread Pend Drill Holes Offset Out of Calibration	Step Qty or Non-conformance Chief Eng Description FAULT CATEGORY General Bend Grain Hardware Broken/Damaged Inspection Incomplete Inspection Incomplete Instructions Incomp	Step Qty or Non-conformance Chief Eng Description Date FAULT CATEGORY General Bend Grain Ovalized Over/Under Broken/Damaged Inspection Incomplete Part Incorre Crimped Burrs Instructions Incomplete Part Incorre Broken/Damaged Inspection Incomplete Part Incorre Crimped Contamination Maintenance Part Moved t Countersink Mislabeled Positioned National Power Loss/ Bend Drill Holes Offset Caves in Extrusion Drawing Out of Calibration	Step Qty or Non-conformance Chief Eng Description Date Verification FAULT CATEGORY

Outside Dimensions

DQA: Date:

Turning Sequence

Wave/Twist in Tube

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print

April-05-13 1:12:58 PM

Work Order ID:

99285

Parent Item:

D3255-3

Parent Item Name:

Cap

Start Date: 4/04/13

Required Date: 4/12/13

Start Qty: 6.00

Required Qty: 6.00

Comments:	IPP Rev:A New	Issue 06-08-01	JLM									
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Status Issued
M304S22GA 304/316 .032 Sheet		Purchased	No			100	sf	209.5600	0.045	0.2842104		Jm 307-30

Location	Loc Qty	Loc Code	
MAT020	209.56		
118271	10.76		
120866	55.6		
121889	143.2		121889

Page 1

!	501	5.
I	DQA:	Date:
1	·	
1		

NCR: Y	es / N	О			WORK ORDER NON-	COI	NFORM	MANCE / UPD	DATE	QA Closed:	Date	
Work Orde	r:				DISPOSITION				AGAINST DE	PARTMENT,	PROCESS	
	1				Rework	7		Skid-tube	Crosstube		Water Jet	Engineering
Part N	o				Scrap	1	ſ	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is]	Therm	noforming	Finishing	Rec/Sto	e/Packaging	Other
NCR N	0				Work Order Update]		Large Fab	Composite]	Supplier	
		 					<u> </u>			T c: 0		
Root					ption of work order update	1	nitial	Act		Sign &	Verification	OC Inchestor
Cause	Dat	e Step	Qty		or Non-conformance	Ch	ief Eng	Descr	iption	Date	verification	QC Inspector
Doc/Data	_											
Equip/Tooling							!					
Operator	_	`										
Material	_											
Setup												
Other												
Process	_											
Supplier	_											
Training	_	:										
Unapproved		,L				AUI	T CATE	GORY			1	
Landin	ng Gear	 		 	General							
[Bendi	ng			Bend		Grain			Ovalized		Pressure/Forced
	Centr	e Not Conce	entric to O	ı/s 🗀	BOM/Route		Hardwa	ire		Over/Under	tolerance	Temperature/Cure
	Crack	5			Broken/Damaged		Inspect	ion Incomplete		Part Incorre	ct	Weld
	Crush	ed/Ċrimped	d		Burrs		Instruct	tions Incomplete/U	Jnclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination		Mainte	enance		Part Moved		
	Heat	reat			Countersink		Mislabe	eled		Positioned	Wrong _	_
	Inspe	ction Strip i	n Tube		Cut Too Short		Misrea	d		Power Loss,	/Surge	Other
	Ripple	s in Bend			Drill Holes		Offset					
[Torqu	e Waves in	Extrusion		Drawing		Out of	Calibration				

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Finish

Folio

DART AEROSPACE LTD	Work Order: ବ୍ୟକ୍ତ	5
Description: Cap	Part Number: D325	5-3
Inspection Dwg: D3255 Rev: B	Page 1	of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

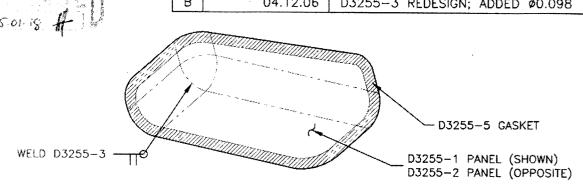
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.44	+/-0.030	2.44"	-		υ	JLmoi
2.69	+/-0.030	2.44" 2.69" 6830"	-		V	
0.032	+/-0.010	0.030"	-		V	
					<u> </u>	
<u> </u>						

Measured by:	Jm	Audited by:	0.9	Prototype Approval:	N/A
Date:	13-07-30	Date:	<u> ප්රාථ්</u> ට	Date:	N/A

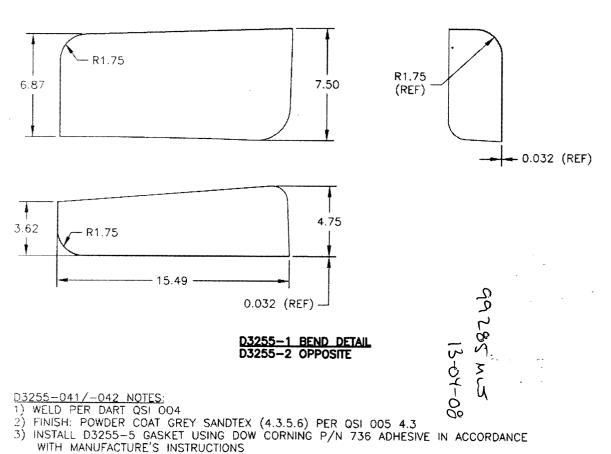
Re	v Date	Change	Revised by	Approved
A	08.10.2		KJ/DD A	N
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	DESIGN DRAWN BY			DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	CHEC	KED 10	APPROVED	DRAWING NO. REV. B	
		41	- Aut	D3255 SHEET 1 OF 4	
	DATE			TITLE SCALE	
****	04.1	04.12.06		ACCESS PANEL ASSEMBLY 1:6	
	Α		04.01.27	NEW ISSUE	
	В		04.12.06	D3255-3 REDESIGN: ADDED @0.098	



D3255-041 ACCESS PANEL (SHOWN) D3255-042 ACCESS PANEL (OPPOSITE)



WITH MANUFACTURE'S INSTRUCTIONS

4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

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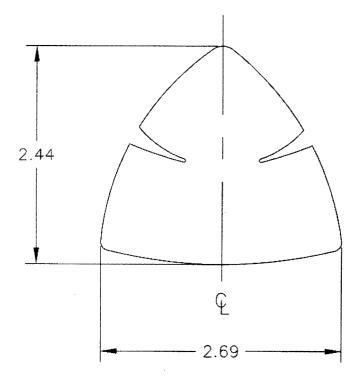
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DESIGN	DRAWN BY	1	ROSPACE LTD
CHECKED	APPROVED	D3255	REV. B SHEET 2 OF 4
DATE		TITLE	SCALE
04.12.06		TITLE	1:1





D3255-3 CAP FORM TO FIT D3155-1/-2

D3255-3 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"

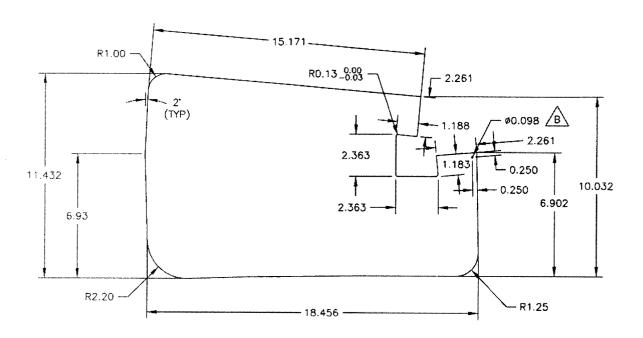
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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED (APPROVED	D3255	REV. B SHEET 3 OF 4	
DATE		TITLE	SCALE	
04.12.06		ACCESS PANEL ASSEMBLY	1:5	





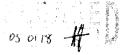
D3255-1/-2 FLAT PATTERN

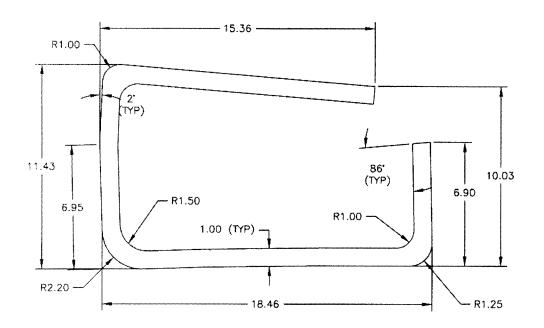
D3255-1/-2 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLÈSS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010



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CHECKED	APPROVED	D3255	REV. B SHEET 4 OF 4
DATE		TITLE	SCALE
04.12.06		ACCESS PANEL ASSEMBLY	1:5





D3255-5 GASKET

D3255-5 NOTES:

- 1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F P/N SIL/F 36x36x1/16

 POSSIBLE SUPPLER: AVIALL

 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

 3) ALL DIMENSIONS ARE IN INCHES

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